HAAS CNC vertical machine #1

1- Mill as per Folio FA649 Rev: A A & Dwg D3502 Rev: B □2-Deburr

per dwg D3502

29 11.8.22 29 11.8.22

QC2- Inspect parts off machine FAI/FAIB

0.00

OC

0.00

Quality Control

120

Memo

Dart Ae	rospace							K
W/O:	v <sub>a</sub>	WORK ORDE	R CHANGES					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #: Fault Category:	NC	R: Yes	No DQ	A:	Date:	

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NCR:	NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action	Section B	Verification	Approval	Approval QC Inspector	
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#### Work Order ID 68951

Tuesday, April 26, 2011 10:44:06 AM



Page 2

Item ID:

D3502-1

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Support

4/26/2011

**Start Qty: 12.00** 

Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Start Date:** 

Approvals:

Process Plan:

**Operation** 

Description

Date:

Tooling:

Date:

Run

Start

Stop



QC:

Required Date: 5/24/2011

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

**Tool ID** 

Date:

Tool # Plan

Code

Accept Qty

Reject

Reject Insp.

130

Sequence ID/

**Work Center ID** 

Memo

QC8- Inspect parts - second check

0.00

JL 11-08-22

Qty

Number

Stamp

Quality Control

140

Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

Mark hole position using DT9430□Drill as per Dwg D3502.

150

HandFinish

Hand Finishing

Chemical Conversion Coat per OSI005 4.1

0.00

Memo

0.00

W/O:	-		WC	ORK ORDER C	HANGES			· ·		
DATE	STEP	PRO	DCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	<b>:</b>	PAR #:	Fault Cate	gory:	No	CR: Yes	No <b>DQ</b>	<b>A</b> :	Date:	
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DATE	STEP	Description of NC		Corrective Action		Ciarra 0		cation	Approval	Approval
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#### Work Order ID 68951

Tuesday, April 26, 2011 10:44:06 AM



Page 3

Item ID:

D3502-1

Accept

Setup Start

**Revision ID:** 

**Start Date:** 

Item Name: Support

Required Date: 5/24/2011

4/26/2011 **Start Qty: 12.00** 

Req'd Qty: 12.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop

Stop



Sequence ID/ Work Center ID

**Operation** Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/ **Run Hours** 

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

160

Powdercoat

Memo

Identify as per dwg & Stock Location: 57 63

DFINISH TIME:

170

Memo

QC3- Inspect Part Finish

0.00

0.00

12 St 11-8-2

Quality Control

180

0.00

Memo

0.00

Packaging Packaging

	•									
W/O:			W	ORK ORDER C	HANGES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Wor	k O	rder	ID	68951

Tuesday, April 26, 2011 10:44:06 AM



Page 4

Item ID:

D3502-1

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

Support

4/26/2011

**Start Qty: 12.00** Req'd Qty: 12.00

Operation

Description

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

**Approvals:** 

Process Plan: Date: **Tooling:** 

Date:

Run

Start

Required Date: 5/24/2011

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/

**Work Center ID** 

190

QC21- Final Inspection - Work Order Release

Memo

**Run Hours** 

0.00

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Quality Control

0.00

M/8,

W/O:	1			V	/ORK ORDER CHAI	NGES					
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### **Picklist Print**

Tuesday, April 26, 2011 10:44:13 AM

Work Order ID: 68951

Parent Item: D3502-1

Parent Item Name: Support



Start Date: 4/26/2011

Required Date: 5/24/2011

Page 1

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-07-06 JLM

IPP Rev:B Add tooling hole 07-03-28

Esr rev C added DT9430 08.11.03 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		rimary ocation	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	26.3100	0.289	3.650526	5		

T KENNEN KIR BUM BEKIR DINE MEKER KIR BIMEK KERKIBEK KERKERIAN BEKIR BEKIR BUKIR BEKIR BUGI MEMIK BUM BEKIR BUM

6061-T6 Bar 1.00 x 4.00

<u>Location</u>	Loc Qty	Loc Code
MAT004	26.31	*
<b>√</b> 107221	22.23	
114352	2.58	
116808	1.5	

W/O:			V	ORK ORDER CHANC	GES				
DATE	STEP	PF	OCEDURE CH	IANGE	E	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	i	PAR #:	Fault Ca	tegory:	NCR:	Yes N	o <b>DQA</b> :	Date: _	
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DART AEROSPACE LTD	Work Order:	48951
Description: Support	Part Number:	D3502-1
Inspection Dwg: D3502 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

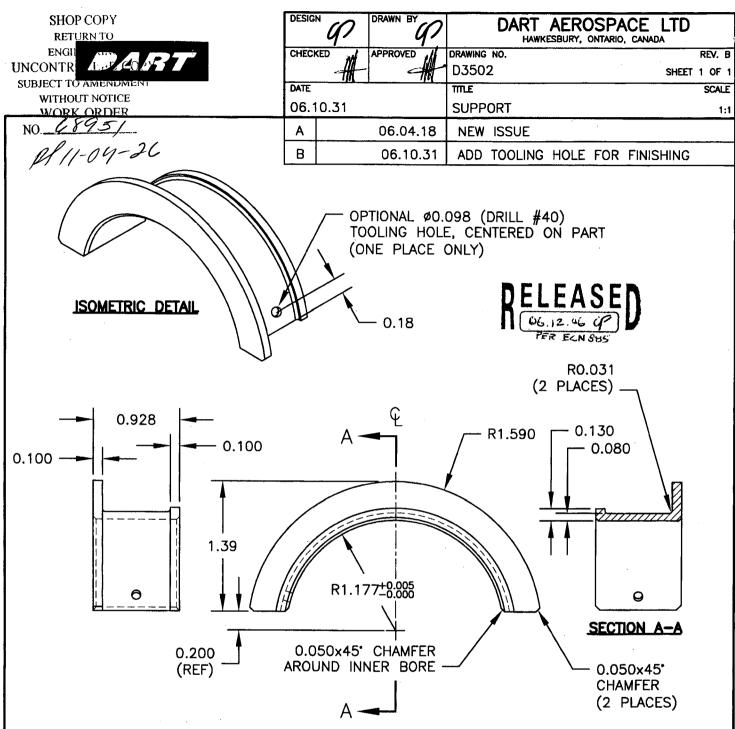
X Fir	st Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R1.590	+/-0.010	R1.593			20,02	
R1.177	+0.005/-0.000	RIIT				
0.130	+/-0.010	132				
0.080	+/-0.010	0000				
0.928	+/-0.010	,928		-		
0.100	+/-0.010	1098				,
0.100	+/-0.010	-102				
1.39	+/-0.030	1,390				
	, , , , , , , , , , , , , , , , , , , ,					
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Measured by:	Rep	Audited by:	ياد	Prototype Approval:	N/A
Date:	11.8-22	Date:	11-08-20	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.09.01	New Issue	KJ/JLM ,	1
В	07.03.29	Dwg Rev. updated	KJ/JLM	
		:	7()	7,007

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DATE	STEP	<b>Description of NC</b> Section A	Corrective Action Section B				Verification		Approval Appro	Approval
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## D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ , X.XX =  $\pm 0.030$ ) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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